

Date: Friday, 12/21/2007 7:27:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT ASSEMBLY
Job Number : 36525	
Estimate Number : 11248	
P.O. Number :	Part Number : D3438042
This Issue : 12/21/2007 S.O. No. :	Drawing Number : D3438 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 35871	Material :
Written By :	Due Date : 1/12/2008 Qty: <i>25</i> Um: Each
Checked & Approved By : <i>12.12.21</i>	
Comment : Est A 05.05.18 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch

B35887

B25396=4

12.02.20 5

2.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch

B34357

12.02.20 5

3.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch

B36533

12.02.20 5

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438 *SAD 08:02:01 (5)*

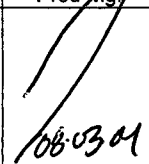

2-Deburr ends *SAD 08:02:01 (5)*

3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343

B 105844 106762 Alm. weld rods

12.02.20 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08:02:01	1.0	Set Step Extrusion D2244-116 to Dwg B3438 Pick B# <u>B33733</u> 08/02/01	SAM	08:02:01	5	 08-03-01	 08-03-01

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 36525

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-21 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Aug 02-21 (5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/02/22

(5X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12 08-02-25 5

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last cap per dwg D3438 & grind flush

12 08-02-25 5

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-25 (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Aug-25 (5)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Touch up alodine

FL 08/02/25 (5)

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005 H/ 08-02-26 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:58 AM
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Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 36525

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

m/06894

FL 08/02/26 (5)

14.0

QC3

INSPECT: POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 8/3/3 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 36495 3P
37064 PC 8/3/3/2P

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/04

Job Completion



m 2008/3/04

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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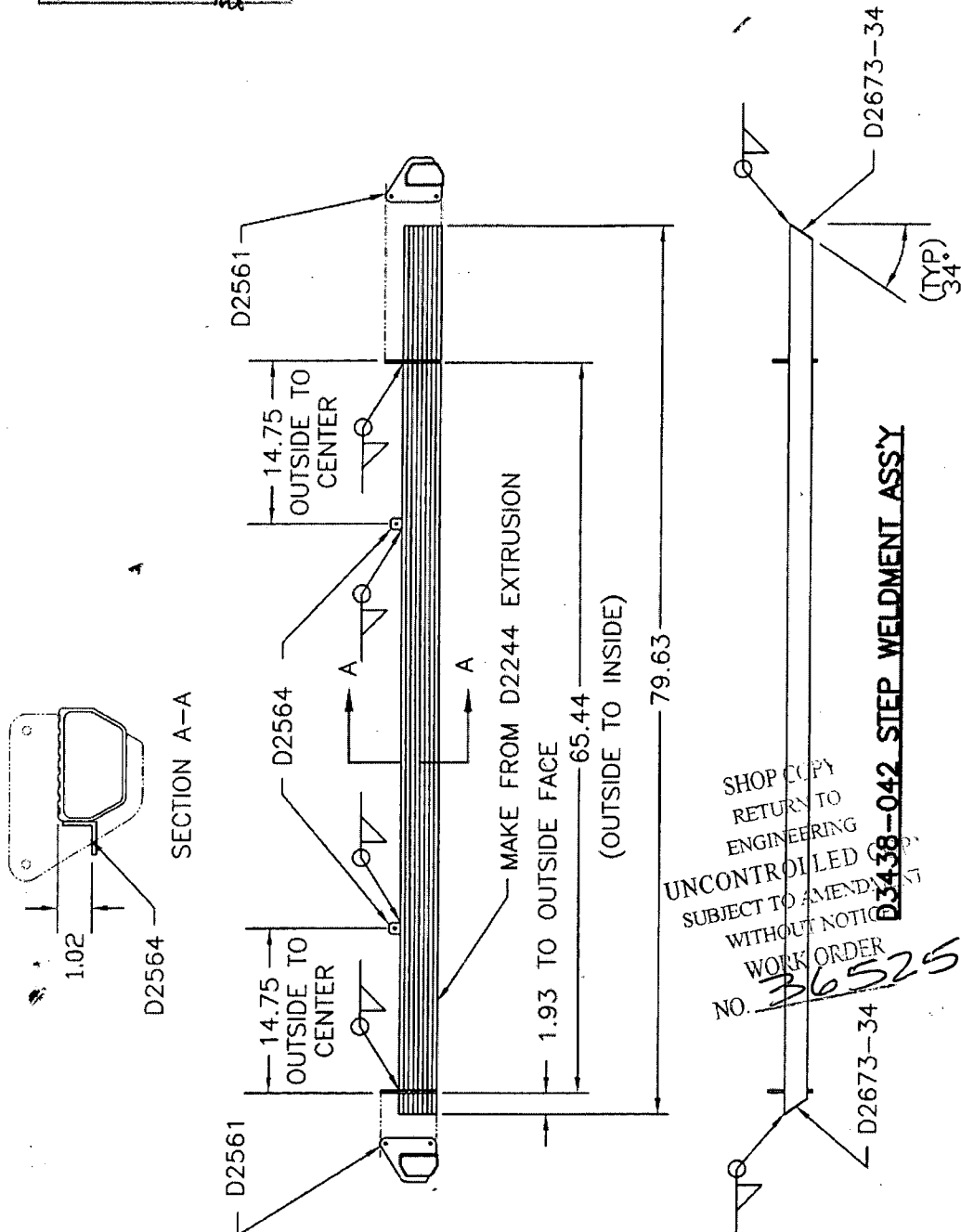
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09		TITLE STEP WELDMENT ASSEMBLY	SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05-05-22 [Signature]

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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